

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009782**Date Inspected:** 16-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Yumin and Li Jia**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Assembly Yard

1AW & 1AAW

SMAW welding performed on weld joint 001 located on OBW1.

Welder is identified as Mr. Chen Zhenghua (220067). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-Repair and CWR829.

1AE

SMAW welding performed on drip plate weld joints 100, 101, 86, 87 and 85 located on OBE1B.

Welder is identified as Mr. Li Bo (050433). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-P-2114-FCM-1 and

WPS-B-P-2113-B-U2-FCM-1.

NDT Observation

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This QA Inspector observed ZPMC Ultra Sonic (UT) Technician performing UT on various locations in the trial assembly yard. Locations are as followed:

1. UT was performed and accepted on weld OBE1-001 (deck plate) repair area with a 70° wedge. Scanning “D” pattern was observed at time of UT inspection. Y location of repair area inspected is approximately 5200~5400. Measurements were taken from the bike path side of segment.
2. UT was performed and on weld OBE1A-003 (bottom plate) repair area with a 70° wedge. Scanning “D” pattern was observed at time of UT inspection. Y location of repair area inspected is approximately 3500~3700. Measurements were taken from the bike path side of segment.
3. UT was performed on floor beam to side plate weld joint located on panel point 8.5 (looking west). Area of inspection is located between the fifth and sixth side plate stiffener from the bottom plate.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

Inspected By:	Alaniz,Joe	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
